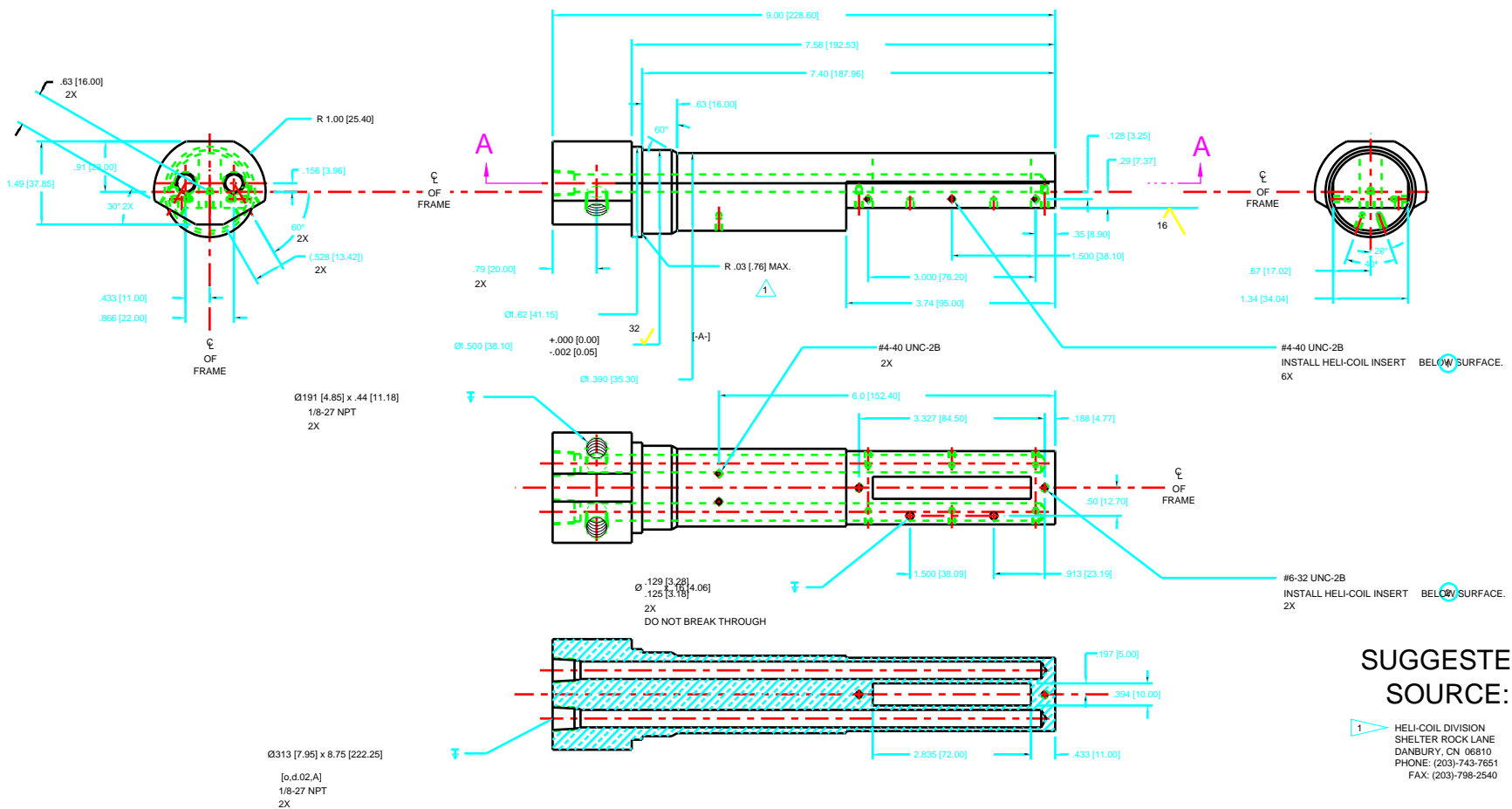


( $\varnothing$ )	PLOT SCALE: 1=1	DWG. SCALE: 1	
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## SUGGESTED SOURCE:

1 HELI-COIL DIVISION  
SHELTER ROCK LANE  
DANBURY, CN 06810  
PHONE: (203) 743-7851  
FAX: (203) 798-2540

### NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.
2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
3. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS.

## SECTION A-A

2	HELI-COIL # 3585-06CNV276	HELI-COIL INSERT, SCREW LOCK, SILVER FINISH #6-32 UNC-2B x .276 LG.	18-8 STAINLESS STEEL	2
1	HELI-COIL # 1185-04CNV224	HELI-COIL INSERT, FREE RUNNING, SILVER FINISH #4-40 UNC-2B x .280 LG.	18-8 STAINLESS STEEL	6
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS				
FRACTIONS				
ANGLES				
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES. DIM. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B4.				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ASME Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A17925				
DRAWN BY PJE DATE 7/93				
CHECKED BY C. BRITE DATE 11/93				
DESIGNER C. BRITE DATE 8/93				
APPROVED/RELEASED C. BRITE 11/93				
MATERIAL: OFHC GRADE 1 PER ANL SPEC. #B 170				
SCALE: 1:1				
SHEET 1 of 1				
TITLE: ADVANCED PHOTON SOURCE F1-APS ID FILTER FRAME, FILTER 2				
DRAWING NUMBER: P4102010107-230101-01				